

Date: Wednesday, 6/6/2007 3:04:17 PM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---|----------------|--------------------------------|--|--|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | CONSOLE SIDE LH (206 HI-SLOPE) | | |
| Job Number | 32819 | Part Number | D26021 | | |
| Estimate Number | 11000 | Drawing Number | D2602 REV A1 | | |
| P.O. Number | N/A | Project Number | N/A | | |
| This Issue | 6/6/2007 | S.O. No. | N/A | | |
| Prsht Rev. | NC | Type | SMALL /MED FAB | | |
| First Issue | | Material | N/A | | |
| Previous Run | 31332 | Due Date | 6/30/2007 Qty: 6 Um: Each | | |
| Written By | | | | | |
| Checked & Approved By | 6/6/07, 06/07 | | | | |
| Comment | Est. D 04.02.25 Rerformat KJ/RF Note: Issue with part number D2602-2 Est Rev:E Now On Waterjet 07-03-22 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: | |
|---|-----------------------|--|--|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet | |
| Comment: Qty.: 1.4146 sf(s)/Unit Total: 8.4874 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M103039(L6)</u> <u>M100747 (2)</u> SAD 07/06/15 | | | |
| 2.0 | WATER JET | FLOW WATER JET | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <u>A1</u> Prog Rev: <u>A1</u> (PJO) | | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/06/15 ⑥ | | | |

| | | | |
|------------------------------------|-----|--------------|--|
| 4.0 | QC8 | SECOND CHECK | |
| Comment: SECOND CHECK S 07/06/18 ⑥ | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2602-1 PAR #: N/A Fault Category: Prod / fab ass' med & small NCR: Yes No DQA: DA Date: 07/08/24
 QA: N/C Closed: DA Date: 07.08.24

| WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|----------------------------------|------|---|-----------------------------|---|-----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/06/15 | 2.0 | Scrap wrong material B# <u>100742M6061S040</u> | <u>Scrap</u> | Scrap, destroy, replace | <u>SAD</u> | | | |
| | | | <u>Scrap</u> | Verify the material prior to using. | <u>07/06/15</u> | <u>EV</u> | <u>07/06/15</u> | <u>051042</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 32819

Part Number: D26021

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SB 07/08/19

6

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CR 07/08/20(16)

6x

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m/f

07/08/22

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/22

6

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/230

6

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

6

Job Completion



07/08/24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 32819 |
| Description: Console Side LH/RH | Part Number: | D2602-1/-2 |
| Inspection Dwg: D2602 Rev: A1 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | SAD | Audited by: | CR | Prototype Approval: | N/A |
| Date: | 07/06/15 | Date: | 07/06/18 | Date: | |

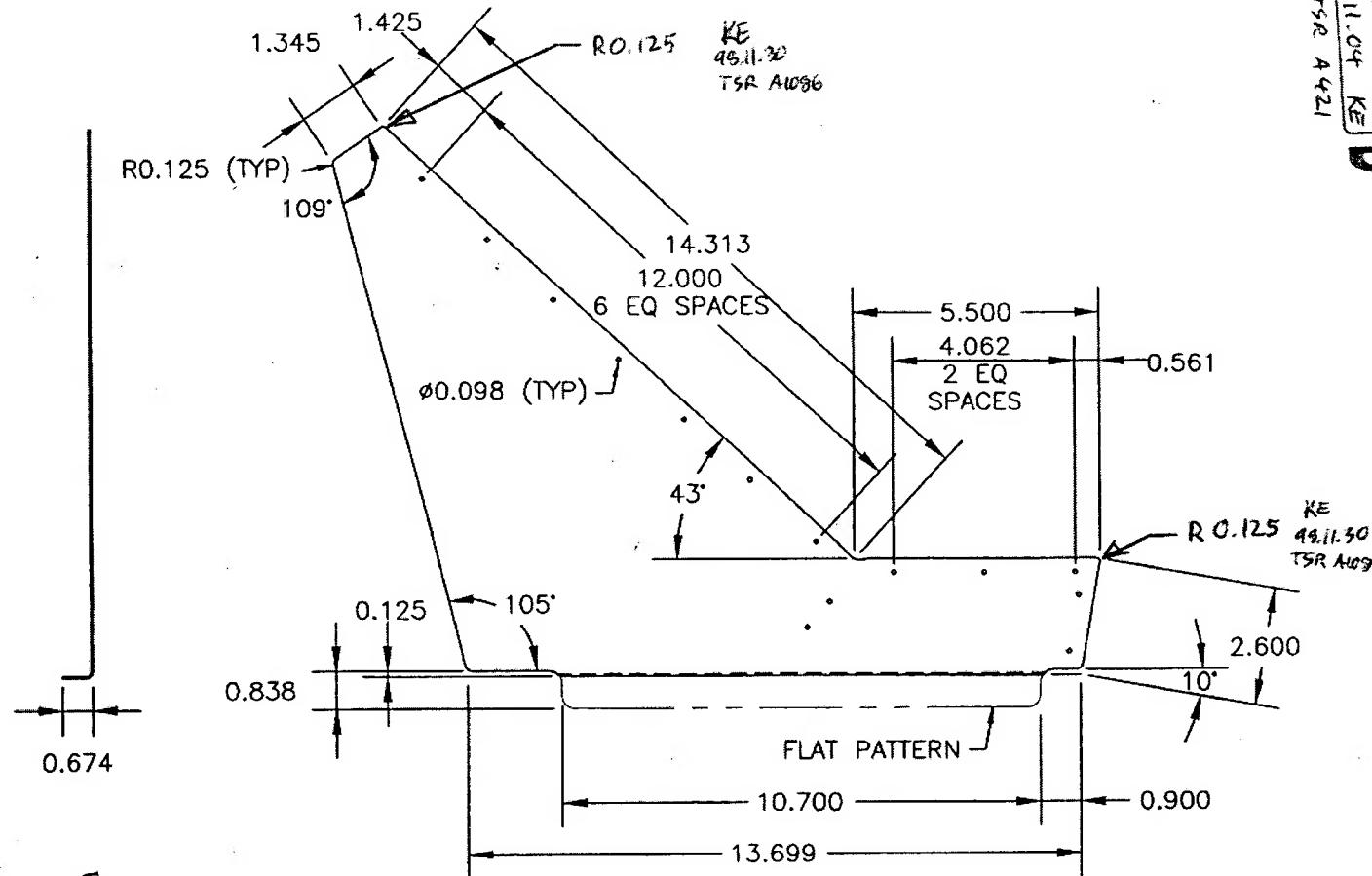
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.02.25 | New Issue | KJ/RF | TT |

DART



RELEASED
97.11.04 KE
TSR A 4421

| | | | |
|---|-------------------------|--|--------------|
| DESIGNER <i>KE</i> | DRAWN BY B.W. | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | REV. A |
| CHECKED <i>KE</i> | APPROVED <i>J</i> | DRAWING NO. D2602 | SHEET 1 OF 1 |
| DATE 97.10.22 | | TITLE CONSOLE SIDE | SCALE 1:4 |
| A AI 97.10.22 97.10.22 | 97.10.22 02.06.04 | ADD FINISH | |



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602

BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 A1
D2602-1 SHOWN
D2602-2 OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32819